

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015435**Date Inspected:** 29-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Bay 04, Deck Panel 13BE-DP3087-001

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13BE-DP3087-001, 8 ribs, 16 welds, 144 total tack welds inspected.

Weld 001 scanned 9 locations with 0 indications.

Weld 002 scanned 9 locations with 1 indication.

Weld 003 scanned 9 locations with 0 indications.

Weld 004 scanned 9 locations with 1 indication.

Weld 005 scanned 9 locations with 1 indication.

Weld 006 scanned 9 locations with 0 indications.

Weld 007 scanned 9 locations with 2 indications.

Weld 008 scanned 9 locations with 0 indications.

Weld 145 scanned 9 locations with 0 indications.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Weld 146 scanned 9 locations with 1 indication.
Weld 147 scanned 9 locations with 0 indications.
Weld 148 scanned 9 locations with 1 indication.
Weld 149 scanned 9 locations with 0 indications.
Weld 150 scanned 9 locations with 0 indications.
Weld 151 scanned 9 locations with 1 indication.
Weld 152 scanned 9 locations with 0 indications.

OPEN YARD; SEGMENT 11AE

This QA inspector performed random Visual Testing (VT) of corner assembly weld joints and deck panel diaphragm weld joints in between panel point 96 & panel point 97 those were previously tested and accepted by ZPMC Quality Control personnel. Several of nonconforming discontinuities (like spatter, porosity, undercuts) were found which marked on the parts. The members are identified as OBG Components.

OBG BAY 14; LIFT 13 SIDE PLATE

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SP3091-001-71, 72, 74 (GREEN TAG NO. 13247)
SP3066-001-15, 16, 29, 30, 43, 44, 57, 58, 71, 72 (GREEN TAG NO. 13246)
SP3098-001-23, 24, 37, 38, 51, 52, 65, 66, 79, 80 (GREEN TAG NO. 13245)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
